PROJECT TITLE : SPECIFICATIONS AND PROCESS ASSURANCE

Period Covered : 1.3. - 26.3.1980
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1. Specifications Fabriques de Tabac Réunies SA

- Following the use of mentholated foil and a subsequent taste test, the same blend 54 BSD Bond LTN will be used for the cigarettes Bond LTN and BSC Bond Menthol.

- The cigarettes MIF Milla and CHF Champion have been modified with regard to the filter length (20 instead of 18 mm) and the tipping paper (48 instead of 44 mm). The tobacco weight has been reduced proportionally.

- The filter and cigarette making specs for the Marlboro Filter and Marlboro King Size MLF MLK cigarettes, manufactured by FTR under contract for P. Morris Holland, have been modified from non-diluted to the semi-diluted versions.

- The packing spec MAA 057 Duty free sales in Great Britain, via Allders, have been re-issued.

- A new product version MAA 067 is manufactured for sale to Air Algérie.

- The packing specs for ALF Arlette have been modified. The last packing group AMF Arbor 223/Focke & Pfuhl has been removed and ALF are now packed on a AMF Arbor 34/G.D. Pack OW group. The materials have changed consequently.

- A new Product version MLY 022 Marlboro Lights is manufactured for sale in Austria.

2. Specifications Intertaba S.p.A. Zola Predosa

- Two new filter making specs have been distributed for the semi-porous and porous Marlboro 108 mm filters, to be sold to PM Holland.

3. Specifications Ph. Morris Holland

- The filter making specs (white semi-porous 108, 120 and 100 mm) are now manufactured with filter paper FU-POV 40 L replacing 24 K.

- All cigarette making specs have been re-issued in an updated form.

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- PM Holland do no longer use non-porous filters. For non-diluted cigarettes, such as NPK North Pole King Size, ROK Roy, and NLF North Pole Filter, the semi-porous filters used are covered with the standard non-perforated tipping paper.

- The reduction of the RTD from 115 to 105 mm WG on NLF North Pole Filter has been approved. The RTD reductions provisionally specified for ROK Roy and MPH Ph. Morris 100s will have to be reviewed.

- The AccuRay equipment has been removed from all 84 mm makers of Eindhoven and transferred to the Bergen OZ production site.

4. Specifications Ph. Morris Germany

- In addition to the standard Italian Marlboro King Size MLK 10, Munich will produce MLK 30 for sale in Italy in the size 63 + 21 = 84 mm, on one cigarette maker already converted to this garniture size (MLK-DB). RTD of 105 mm and dilution of 7 % are expected to remain unchanged.

- Munich has started the production of the diluted version of the German Marlboro King Size MLK 12, following the product development phase. The cigarette is manufactured with a new blend, a porous filter (24 K paper), a zone perforated tipping paper Z3/70, an RTD of 105 mm WG and a dilution of 15 %.

- The original Parliament PLL 01 tipping paper, purchased with PM USA previously, has been replaced by a 64 mm tipping paper supplied by Tann.

- The filter and cigarette making cigarettes for PMS Ph. Morris Super Lights, as well as the cigarette making specs for LAG 01 Lark, have been corrected (RTDs) according to product development's recommendations (new products).

- The complete specs sets for EFH Efes 100s and TKH Topkapi 100s, manufactured under license of the Turkish Monopoly, have been withdrawn. The contact between the two firms will expire at the end of April, 1980.

5. Specifications WELTAB SA Bruxelles

- The cigarette making spec MLF 22, for sale in Italy, has been modified from the non-diluted to the diluted version.

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- A new packing version Merit MER 052, in HL pack, for the Dutch market, has been produced.

- The packing specs for
  - MLK 152 (MLB 152), in display carton, sale in GB,
  - MER 012 Merit, in 25s soft pack, for sale in NL
  - MLK 152, Molins packer,

  have been withdrawn.

6. Specifications Ph. Morris Great Britain

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7. Specifications Licensees

- Finland: The re-engineered BEO Belmont Extra Mild cigarette is manufactured with a porous filter, Hauni dilution on a 27 mm wide tipping paper, and a dilution of the cigarette of 24 % (previously 15 %).

- The cigarette length of all Finnish brands has been reduced (in 1974) from 20 + 60 to 20 + 59,4 = 79,4 mm.

- Complete new specs have been established for ATO, Finland, for the two brands CEK Chesterfield and PMK Ph. Morris King Size, both 84 mm plain cigarettes in soft packs.

- Complete sets of specs have been prepared for the L & M products manufactured at Suomen Tupakka OY, Helsinki, Finland, i.e.LMB L & M HL pack for sale in Finland and Norway, and LMC L & M soft pack, for sale in Finland, have been prepared.

- Complete manufacturing specifications are available for Manchester Tobacco Company, for the manufacture of their L & M products, i.e. CEG Chesterfield King Size Filter Box, for sale in Great Britain, Ireland, and Danemark, and LMG L & M King Box, for sale in Great Britain and Ireland.

- Italy: The MAA Ambassador specs for Bologna have been modified and foresee the addition of 3,12 % Esther as in Rovereto.
  The MLF Marlboro specs for Bologna have been modified, since 3,33 % Esther will be added as from May, 1980.

8. Material Specifications

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9. PME Standard Recipes

- The RUM-AC recipe has been modified with regard to the application rate of solution to the Dutch RUM Runner Menthol blend.

- Three new recipes have been established for Chesterfield and L & M products.

10. Specifications on EDP

- Authorization has been received for a detailed study of rentability.

11. Process Assurance

11. 1. Objectives of Process Assurance

Expressed in a condensed way, the objectives of "Process Assurance" are the following:

- Create a more detailed description of the processes applied.
- Improve the concept of the specifications so as to obtain a better "protection" of the product.
- Define methods and procedures which allow to verify the respect of the spedifications.
- Try to standardize identical products manufactured in different production centers, and be able to justify each deviation.

The different subjects presently studied or planned to be handled are listed below.

11. 2. AccuRay

- Comparison between the affiliates of the different systems used to check the installation.
- Review of the document "Esplanations to the AccuRay limits".
- Define a common system for the check of the ArruRay system, as far as possible.
- Determine an identical method for the calculation of the AccuRay limits mentioned in the specifications.

11. 3. Moistures

Establishment of a comparative table of the moistures presently valid in all production centers (moistures of cigarettes after packing and after cigarette maker).

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11. 4.Non-Tobacco Material Weight

A common procedure of calculation for the determination of the weights of glues and materials used in the filter and cigarette making departments has to be laid down.

11. 5. Transport Jets (Filter Making)

A situation report will be prepared once all information and complete documentation will have been collected.

11. 6. Filter and Cigarette Diameters

Comparative table of the principal brands.

11. 7. RTDs and Dilution

Comparative table.

11. 8. Foil mentholating

Following the numerous questions from PMH and PMG, the actual method, prepared by FTR, will have to be completed.

11. 9. Kitchen

A study of the methods applied in the affiliates will be made and will cover the points:
Check of the standard recipes / Kitchen recipes / Ingredients / Solutions and their application.

11. 10. Primary

A first study concerning the present situation (equipment and processes) in FTR, WELTAB, and PMG Munich, has to be carried out.
Following the construction of the new processing departments in PMH Bergen op Zoom and PMG Berlin, we will be able to decide in which sense the specifications and checking methods will have to be modified and improved.

11. 11. Proctor & Schwartz

To answer to a request of PMH, a comparison of the systems applied in FTR and PMG Munich has been prepared.

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